Fixturing systems

Basic sets for CMM's from LK Metrology





dk
FIXIERSYSTEME

Maximum modularity for – optimum application flexibility

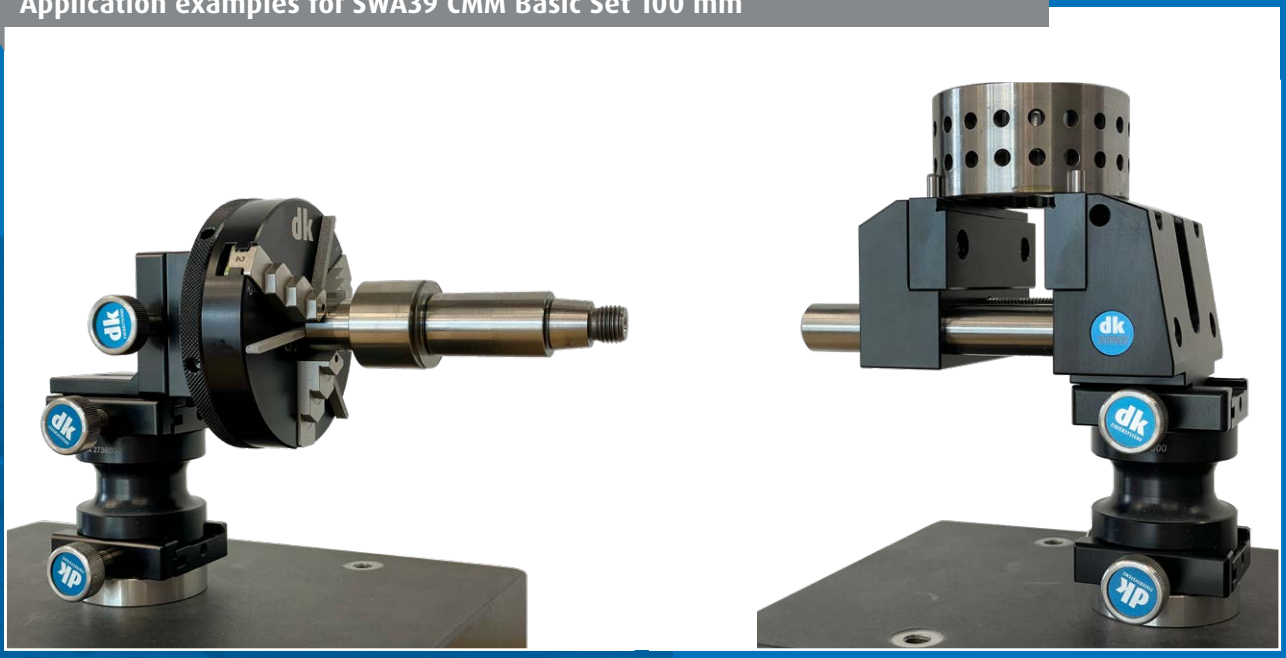
SWA39 Modular systems for small parts

modular. simple. better. Versatile modular systems for coordinate measuring machines. Unique, excellent and proven due to a quick-change system with reproducible zero points. The basic sets compiled here can be almost endlessly expanded due to a huge selection of base, extension, adjustment and clamping elements with standardised interfaces. Individual elements and entire fixture configurations can be changed rapidly. The fixtures can be dismantled an infinite number of times and newly reassembled or reassembled identically with repeat accuracy.
The clamping elements can also be used with all other measuring technologies and on all metrology machines.

Application examples for SWA39 CMM Basic Set 50 mm



Application examples for SWA39 CMM Basic Set 100 mm

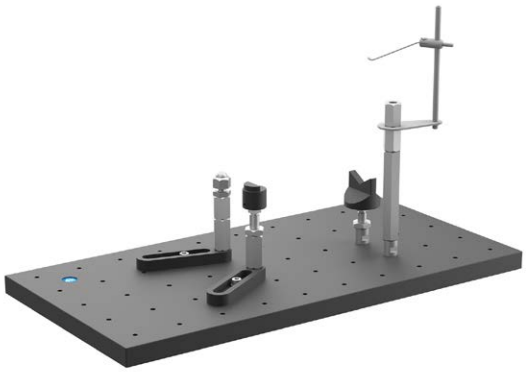


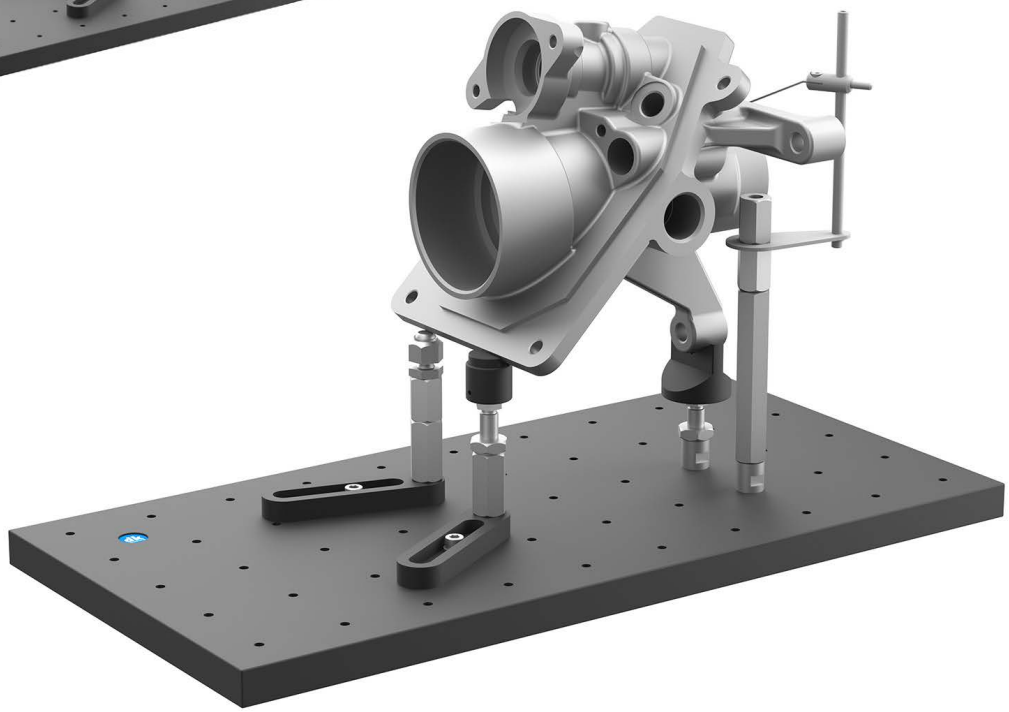
SPANNFIX ECO
Column structural systems for larger components

FAST. REASSEMBLY. LIFELONG. The modular system enables precise positioning, fixating and clamping, whilst ensuring optimum access to the test specimen. The individual components are intelligently coordinated with one another and, through their diversity, are also suitable for even the most complex workpiece geometries. Configurations can be quickly generated from the modular system for e.g. the measurement of prototypes and can also be quickly dismantled again. For mass-produced items, the fixture is left in place for the entire life cycle and is dismantled when the manufactured product is no longer produced. Unlike special fixtures milled from solid material, which afterwards are only worth their scrap value, the fixture built using the SPANNFIX ECO modular system is returned to the parts store and reused for new fixtures. The modular principle therefore saves both time and money; it is thus both economical and environmentally friendly.



Application examples





Interface to the measuring machine: quick-action clamp

SWA39 Quick-action clamps with fastening screw

Description	Order number
Thread size M6	285206
Thread size M10	285210



SWA39 CMM Basic Set 50 mm

Order number: 269996

SWA39 quick-action clamp with 61 mm fixed height extension

Description	Order number
Extension module for raised fixturing	273600



SWA39 quick-action clamp 90° fixed angle element

Positioning element with a fixed 90°angle	283300



Precision vice 50 mm

With SWA39 interface; set including an adjustable stop, a span extension from 35 to 75 mm, a magnetic knurled knob and pins for raised part positioning	282100



Stepped pins, for 50 mm vice

4 pins, 24 mm long for raised fixation to ensure optimum accessibility	282300



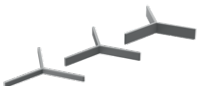
Precision three-jaw chuck 50 mm

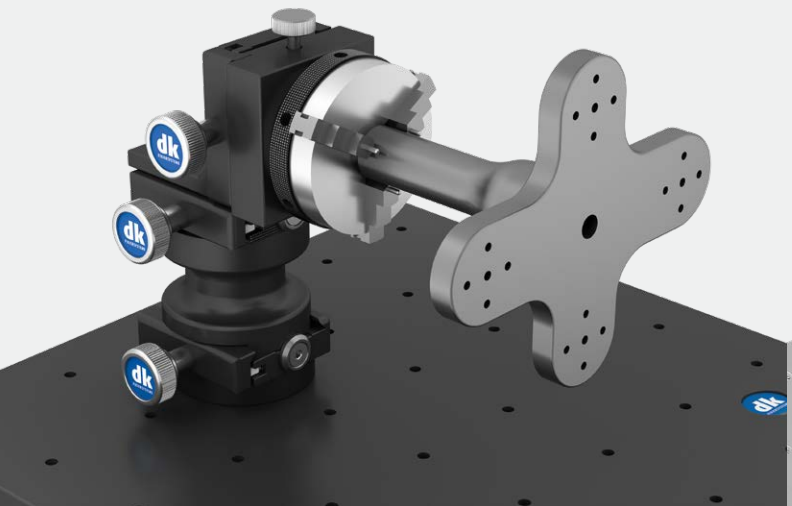
With SWA39 interface; manually operated three-jaw chuck with tool-free reversible stepped hard jaws for internal and external clamping of rotationally symmetrical workpieces; with pin holes and pins for the raised clamping of parts, making them accessible from all sides	329705

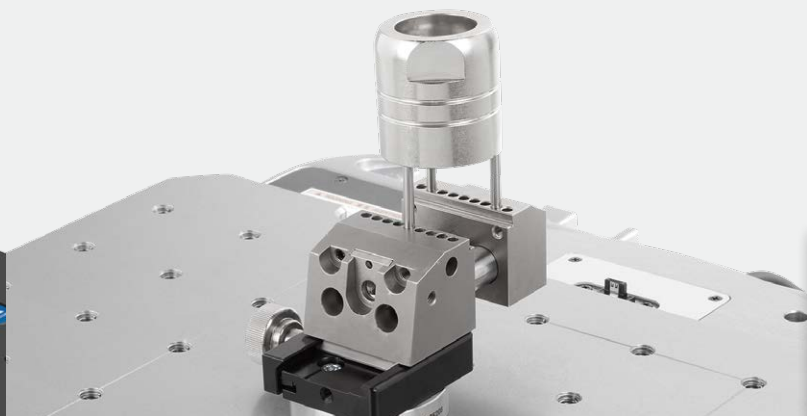


Seating as depth stops for 50 mm jaw chucks

1 set of seats to act as depth stops, ensuring that the clamped workpieces are positioned with repeatable accuracy; heights: 3 mm, 5 mm, 7 mm	283250







SWA39 CMM Basic Set 100 mm

Order number: 269997

SWA39 quick-action clamp with 61 mm fixed height extension



Description	Order number
Extension module for raised fixturing	273600

SWA39 quick-action clamp 90° fixed angle element



Positioning element with a fixed 90°angle	283300

Precision vice 100 mm



With SWA39 interface; including adjustable stop, span extension from 80 to 170 mm, pins for raised part positioning and operating tools	308500

Stepped pins, for 100 mm vice



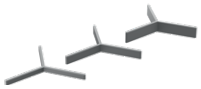
4 pins, 36 mm long for raised fixation to ensure optimum accessibility	307810

Precision three-jaw chuck 100 mm



With SWA39 interface; manually operated three-jaw chuck with tool-free reversible stepped hard jaws for internal and external clamping of rotationally symmetrical work-pieces; with pin holes and pins for the raised securing of parts, making them accessible from all sides	283220

Seating as depth stops for 100 mm jaw chucks



1 set of seats to act as depth stops, ensuring that the clamped workpieces are positioned with repeatable accuracy; heights: 5 mm, 8 mm, 12 mm	283255







SPANNFIX ECO - CMM Starter Set M609

Order number 285175

SPANNFIX ECO baseplate

Description	Quantity	Order number
Baseplate M6, hole grid 50 mm, WxDxH 500x250x20 mm	1	395030



Clamping claws

Description	Quantity	Order number
Clamping claws for M8, m10 and M12 threads	3	281440



Base rail M10

Description	Quantity	Order number
Base rail 105 mm with M6 screw for baseplate	3	322010



Thread reducer

Description	Quantity	Order number
M6 external / M8 internal for 3D central clamping joint	2	275000
M6 external / M10 internal for hex columns	2	275010



Hex columns M10, AF 17

Description	Quantity	Order number
25 mm	4	322200
35 mm	4	322300
50 mm	4	322400
100 mm	4	304400



Quick-change adapter M10/SWA8

Description	Quantity	Order number
Quick-change adapter M10 for SWA8 modules	2	329500



SWA8 centre

Description	Quantity	Order number
90° centres with SWA8 quick-change adapter, Ø25 mm	2	303700



Flat support SWA8

Description	Quantity	Order number
Flat support, straight stop, SWA8	1	303810
Flat support, corner stop, SWA8	1	303815



Prism support SWA8

Description	Quantity	Order number
40 mm, SWA8	1	323400
8 mm, SWA8	1	323500



Self-aligning pads M10

Description	Quantity	Order number
To compensate for inclinations ± 15°	2	323000



SPANNFIX ECO - CMM Starter Set M610 (continued)

Order number: 285175

Screw jacks M10

Description	Quantity	Order number
With 90° cone point, Ø10	2	322600
With 5 mm tip radius	2	322700



Adapter plate for M6 columns

Description	Quantity	Order number
50 mm, for mounting on M10 columns, pendulum, form and quick-change adapters	4	353700
75 mm, for mounting on M10 columns, pendulum, form and quick-change adapters	4	353800



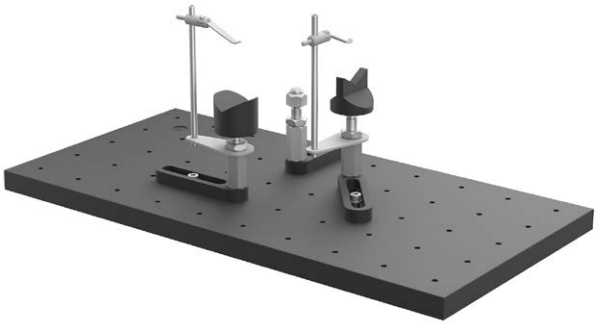
Ø6 column with M6 thread

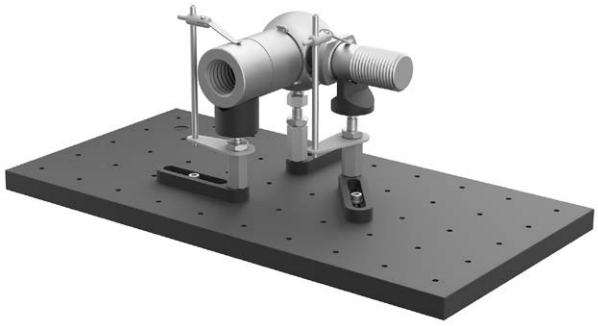
Description	Quantity	Order number
75 mm, for spring finger or as stop, with hex socket	6	368300
125 mm, for spring finger or as stop, with hex socket	6	368500

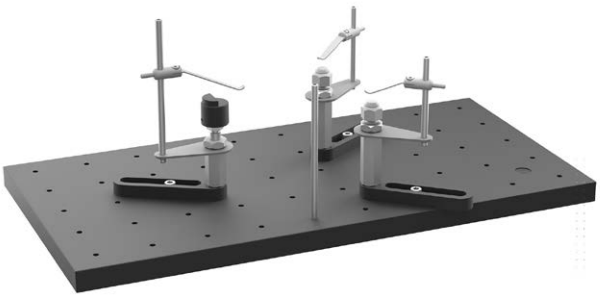


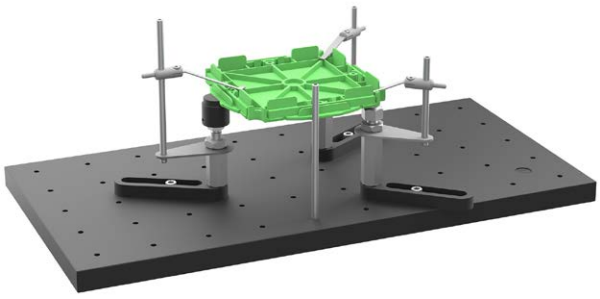
Spring finger Ø 6

Description	Quantity	Order number
50 mm, self-locking and individually adaptable	4	302800
75 mm, self-locking and individually adaptable	4	302900









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modular. simple. better.

The entire world of fixating, clamping and positioning

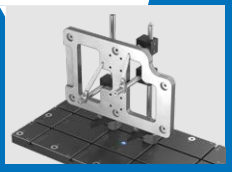
The comprehensive standard construction sets with around 1,000 parts by dk FIXIERSYSTEME for metrology technology offer the following advantages:

» Modular system that has grown and been tried and tested for decades
» Modularity across different lines
» Solutions for every positioning task
» Efficiency through synergetic effects through several industry solutions

SWA39



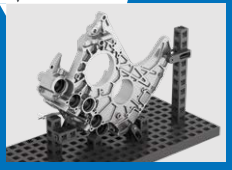
SPANN**FIX** PRO



SPANN**FIX** ECO



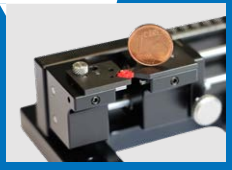
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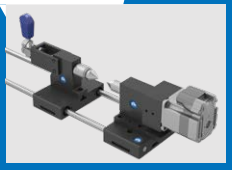
MICRO**FIX**



SWA39CT



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FAST REASSEMBLY LIFELONG

ARTICULATED SYSTEMS



MACHINE VISION



The basic principle of all dk FIXIERSYSTEME!

Our fixtures have a modular design, may be dismantled at any time and reassembled to their initial state. The compatibility of dk FIXIERSYSTEME ensures perfect utility value.